

Date: Wednesday, 02/04/2008 11:27:18 AM  
User: Julie Lecocq

## Process Sheet









<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HELI ACCESS HANDLE WELDMENT ASS'Y, RH
<b>Job Number</b> :	38293		
<b>Estimate Number</b> :	10947		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2480012
<b>This Issue</b> :	02/04/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2480 REV A1
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38222	<b>Drawing Revision</b> :	A1
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JD 08.04.02</u>	<b>Due Date</b> :	09/04/2008
<b>Comment</b> :	Est. C1 03.01.09 Added Powder Coat		

Qty: 3 Um: Each

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2478	Lower Arm
<div><div></div><div></div></div>		
<div><div><div>Comment: Qty.: 1.0000 Each(s)/Unit    Total : 3.0000 Each(s)</div><div>Lower Arm</div><div>Pick:</div><div><div><div>Qty</div><div>Part number</div><div>Description</div><div>Batch</div></div><div><div>1</div><div>D2478</div><div>Heli Access Handle</div><div>B38146 ✓</div></div></div><div>08-04-07 8P</div></div></div>		
2.0	D2479	Upper Arm
<div><div></div><div></div></div>		
<div><div><div>Comment: Qty.: 1.0000 Each(s)/Unit    Total : 3.0000 Each(s)</div><div>Upper Arm</div><div>Pick:</div><div><div><div>Qty</div><div>Part number</div><div>Description</div><div>Batch</div></div><div><div>1</div><div>D2479</div><div>Heli Access Handle</div><div>B38228 ✓</div></div></div><div>08-04-07 8P</div></div></div>		
3.0	D2481	Lower Mount Plate
<div><div></div><div></div></div>		
<div><div><div>Comment: Qty.: 2.0000 Each(s)/Unit    Total : 6.0000 Each(s)</div><div>Lower Mount Plate</div><div>Pick:</div><div><div><div>Qty</div><div>Part number</div><div>Description</div><div>Batch</div></div><div><div>2</div><div>D2481</div><div>Mounting Plate</div><div>B38147 ✓</div></div></div><div>08-04-07 8P</div></div></div>		
4.0	D2482	Upper Mount Plate
<div><div></div><div></div></div>		
<div><div><div>Comment: Qty.: 1.0000 Each(s)/Unit    Total : 3.0000 Each(s)</div><div>Upper Mount Plate</div><div>Pick:</div><div><div><div>Qty</div><div>Part number</div><div>Description</div><div>Batch</div></div><div><div>1</div><div>D2482</div><div>Mounting Plate</div><div>B23504 ✓</div></div></div><div>08-04-07 8P .</div></div></div>		

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, RH

Job Number: 38293

Part Number: D2480012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

M106762

08-01-07

(3X) 8P

6.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 08-01-07 (3)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 08/04/07 (3) 3P

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107550

08-04-08

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-08 (X3)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 38276

08-04-09 (X3)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



mf 08-04-09

W

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

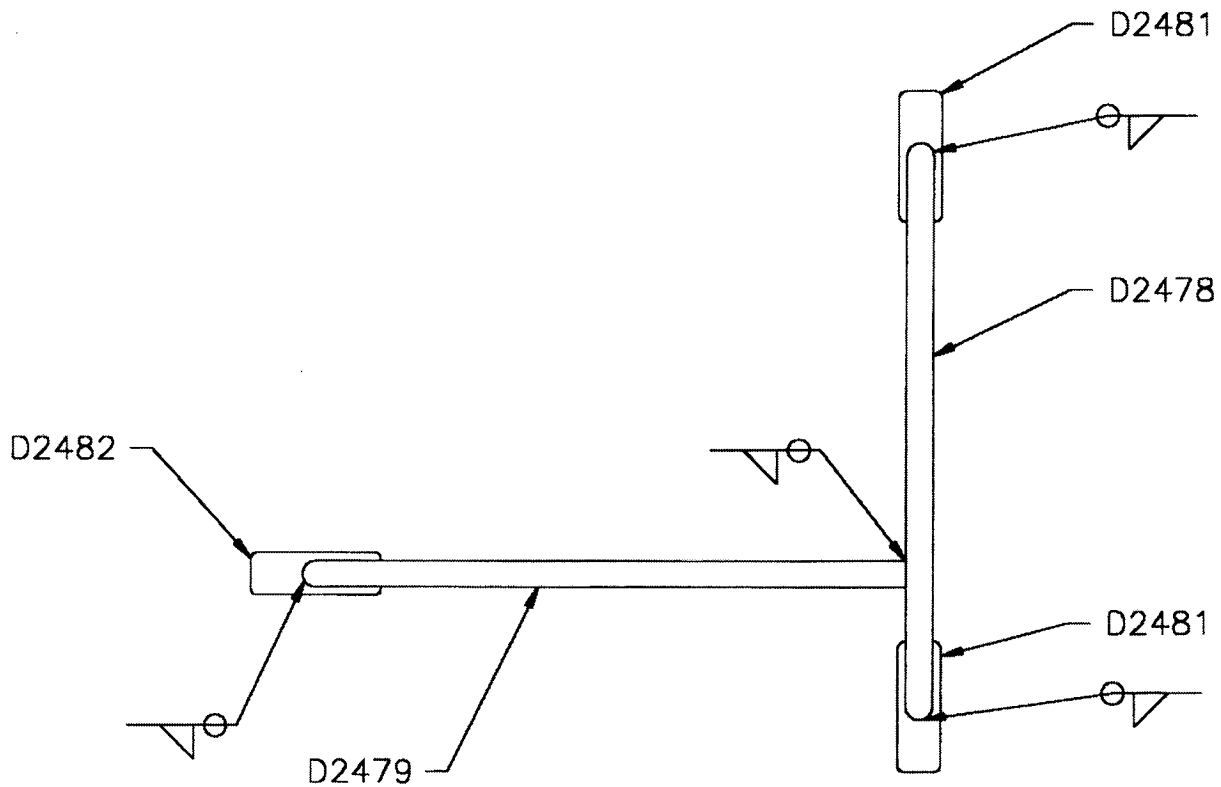
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1 <del>11/10/96</del> 05.06.23		ADDED POWDER COAT	

RELEASED  
96/10/02 DS



D2480-011 LH SHOWN  
D2480-012 RH OPPOSITE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38293

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004  
2) Powder coat white gloss (REF: 4.3.5.2) AS PER QSI 005